

SECTION 05511

METAL STAIRS

PART 1 - GENERAL

0.1 DESCRIPTION OF WORK

- A.** Work Included: This Section specifies the following items.
1. Preassembled steel stairs with treads.
 2. Steel tube railings attached to metal stairs.
 3. Steel tube handrails attached to walls adjacent to metal stairs.
- B.** Related Work: The following items are not included in this Section and will be performed under the designated Sections:
1. Section 03300 - CAST-IN-PLACE CONCRETE for concrete fill for stair treads and platforms.
 2. Section 05500 - Miscellaneous METALS for metal treads and nosings not installed in metal stairs.
 3. Section 09260 - GYPSUM BOARD ASSEMBLIES for metal backing for anchoring railings.

0.2 PERFORMANCE REQUIREMENTS

- A.** Structural Performance of Stairs: Provide metal stairs capable of withstanding the effects of gravity loads and the following loads and stresses within limits and under conditions indicated:
1. Uniform Load and Concentrated Loads: As required by Code.
 2. Stair Framing: Capable of withstanding stresses resulting from railing loads in addition to loads specified above.
 3. Limit deflection of treads, platforms, and framing members to $L/360$ or $1/4$ inch, whichever is less.
- B.** Structural Performance of Railings: Provide railings capable of withstanding the effects of gravity loads and Code required loads and stresses within limits and under conditions indicated:
- C.** Seismic Performance: Provide metal stairs capable of withstanding the effects of earthquake motions determined according to Code.

0.3 SUBMITTALS

- A.** Product Data: For metal stairs and the following:

1. Site-filled metal-pan stair treads.
 2. Paint products.
 3. Grout.
- B.** Shop Drawings: Include plans, elevations, sections, details, and attachments to other work.
1. Provide templates for anchors and bolts specified for installation under other Sections.
 2. For installed products indicated to comply with design loads, include structural analysis data signed and sealed by the qualified professional engineer licensed in the Commonwealth of Massachusetts responsible for their preparation.
- C.** Welding certificates. Qualifications for welding procedures and welders.
- D.** Weld inspection reports.
- E.** Qualification Data: For professional engineer licensed in the Commonwealth of Massachusetts.

0.4 QUALITY ASSURANCE

- A.** Installer Qualifications: Fabricator of products.
- B.** NAAMM Stair Standard: Comply with "Recommended Voluntary Minimum Standards for Fixed Metal Stairs" in NAAMM AMP 510, "Metal Stairs Manual", for class of stair designated, unless more stringent requirements are indicated.
1. Preassembled Stairs: Commercial class.
 2. Ornamental Stairs: Architectural class.
- C.** Welding: Qualify procedures and personnel according to the following:
1. AWS D1.1, "Structural Welding Code--Steel".
 2. AWS D1.3, "Structural Welding Code--Sheet Steel".
- D.** As a minimum, welds shall be visually inspected.

0.5 COORDINATION

- A.** Coordinate installation of anchorages for metal stairs. Furnish setting drawings, templates, and directions for installing anchorages, including sleeves, concrete inserts, anchor bolts, and items with integral anchors, that are to be embedded in concrete or masonry. Deliver such items to Project site in time for installation.

- B.** Coordinate locations of hanger rods and struts with other work so that they will not encroach on required stair width and will be within the fire-resistance-rated stair enclosure.

PART 2 - PRODUCTS

0.1 METALS, GENERAL

- A.** Metal Surfaces, General: Provide materials with smooth, flat surfaces, unless otherwise indicated. For components exposed to view in the completed Work, provide materials without seam marks, roller marks, rolled trade names, or blemishes.

0.2 FERROUS METALS

- A.** Steel Plates, Shapes, and Bars: ASTM A 36/A 36M.
- B.** Steel Tubing: ASTM A 500 (cold formed) or ASTM A 513, Type 5 (mandrel drawn)
- C.** Rolled-Steel Floor Plate: ASTM A 786/A 786M, rolled from plate complying with ASTM A 36/A 36M or ASTM A 283/A 283M, Grade C or D.
- D.** Uncoated, Hot-Rolled Steel Sheet: ASTM A 1011/A 1011M commercial steel, Type B, or structural steel, Grade 30, unless another grade is required by design loads.
- E.** Galvanized Steel Sheet: ASTM A 653/A 653M, G90 coating, either commercial steel, Type B, or structural steel, Grade 33, unless another grade is required by design loads.

0.3 FASTENERS

- A.** General: Provide zinc-plated fasteners with coating complying with ASTM B 633, Class Fe/Zn 25 for exterior use, and Class Fe/Zn 5 where built into exterior walls. Select fasteners for type, grade, and class required.

0.4 MISCELLANEOUS MATERIALS

- A.** Welding Rods and Bare Electrodes: Select according to AWS specifications for metal alloy welded.
- B.** Shop Primers: Provide primers that comply with Section 09900 - PAINTING.

- C.** Zinc-Rich Primer: Complying with SSPC-Paint 20 or SSPC-Paint 29 and compatible with topcoat.
 - 1. Use primer with a VOC content of 420 g/L (3.5 lb/gal.) or less when calculated according to 40 CFR 59, Subpart D (EPA Method 24).
- D.** Galvanizing Repair Paint: High-zinc-dust-content paint for regalvanizing welds in steel, complying with SSPC-Paint 20.
- E.** Bituminous Paint: Cold-applied asphalt emulsion complying with ASTM D 1187.
- F.** Concrete Materials and Properties: Comply with requirements in Section 03300 - CAST-IN-PLACE CONCRETE for normal-weight, air-entrained, ready-mix concrete with a minimum 28-day compressive strength of 4000 psi, unless otherwise indicated.

0.5 FABRICATION, GENERAL

- A.** Provide complete stair assemblies, including metal framing, hangers, struts, railings, clips, brackets, bearing plates, and other components necessary to support and anchor stairs and platforms on supporting structure.
 - 1. Join components by welding, unless otherwise indicated.
 - 2. Use connections that maintain structural value of joined pieces.
 - 3. Fabricate treads and platforms of exterior stairs so finished walking surfaces slope to drain.
- B.** Preassembled Stairs: Assemble stairs in shop to greatest extent possible. Disassemble units only as necessary for shipping and handling limitations. Clearly mark units for reassembly and coordinated installation.
- C.** Cut, drill, and punch metals cleanly and accurately. Remove burrs and ease edges to a radius of approximately 1/32 inch, unless otherwise indicated. Remove sharp or rough areas on exposed surfaces.
- D.** Form bent-metal corners to smallest radius possible without causing grain separation or otherwise impairing work.
- E.** Form exposed work true to line and level with accurate angles and surfaces and straight edges.
- F.** Weld connections to comply with the following:
 - 1. Use materials and methods that minimize distortion and develop strength and corrosion resistance of base metals.
 - 2. Obtain fusion without undercut or overlap.
 - 3. Remove welding flux immediately.

4. Weld exposed corners and seams continuously, unless otherwise indicated.
 5. At exposed connections, finish exposed welds and surfaces smooth and blended so no roughness shows after finishing and contour of welded surface matches that of adjacent surface.
- G.** Form exposed connections with hairline joints, flush and smooth, using concealed fasteners where possible. Where exposed fasteners are required, use Phillips flat-head (countersunk) screws or bolts unless otherwise indicated. Locate joints where least conspicuous.
- H.** Fabricate joints that will be exposed to weather in a manner to exclude water. Provide weep holes where water may accumulate.

0.6 STEEL-FRAMED STAIRS

A. Stair Framing:

1. Fabricate stringers of steel plates or channels. Provide closures for exposed ends of stringers.
2. Construct platforms of steel plate or channel headers and miscellaneous framing members as needed to comply with performance requirements.
3. Weld stringers to headers; weld framing members to stringers and headers.
4. Where stairs are enclosed by gypsum board or shaft-wall assemblies, provide hanger rods or struts to support landings from floor construction above or below. Locate hanger rods and struts where they will not encroach on required stair width and will be within the fire-resistance-rated stair enclosure.
5. Where masonry walls support metal stairs, provide temporary supporting struts designed for erecting steel stair components before installing masonry.

B. Metal-Pan Stairs: Form risers, subtread pans, and subplatforms to configurations shown from steel sheet of thickness needed to comply with performance requirements but not less than 0.0677 inch.

1. Steel Sheet: Uncoated hot-rolled steel sheet, unless otherwise indicated.
2. Directly weld metal pans to stringers; locate welds on top of subtreads where they will be concealed by concrete fill. Do not weld risers to stringers.
3. Shape metal pans to include nosing integral with riser.
4. Provide subplatforms of configuration indicated or, if not indicated, the same as subtreads. Weld subplatforms to platform framing.

0.7 STEEL TUBE RAILINGS

- A.** General: Fabricate railings to comply with requirements indicated for design, dimensions, details, finish, and member sizes, including wall thickness of tube, post spacings, and anchorage, but not less than that needed to withstand indicated loads.
- B.** Welded Connections: Fabricate railings with welded connections. Cope components at connections to provide close fit, or use fittings designed for this purpose. Weld all around at connections, including at fittings.
- C.** Form changes in direction of railings as detailed on the Drawings.
- D.** Form simple and compound curves by bending members in jigs to produce uniform curvature for each repetitive configuration required; maintain cross section of member throughout entire bend without buckling, twisting, cracking, or otherwise deforming exposed surfaces of components.
- E.** Close exposed ends of railing members with prefabricated end fittings.
- F.** Provide wall returns at ends of wall-mounted handrails, unless otherwise indicated. Close ends of returns unless clearance between end of rail and wall is 1/4 inch or less.
- G.** Brackets, Flanges, Fittings, and Anchors: Provide wall brackets, end closures, flanges, miscellaneous fittings, and anchors for interconnecting components and for attaching to other work. Furnish inserts and other anchorage devices for connecting to concrete or masonry work.
 - 1. Connect posts to stair framing by direct welding, unless otherwise indicated.
 - 2. For galvanized railings, provide galvanized fittings, brackets, fasteners, sleeves, and other ferrous-metal components.
 - 3. For nongalvanized railings, provide nongalvanized ferrous-metal fittings, brackets, fasteners, and sleeves, except galvanize anchors embedded in exterior masonry and concrete construction.
- H.** Fillers: Provide fillers made from steel plate, or other suitably crush-resistant material, where needed to transfer wall bracket loads through wall finishes to structural supports. Size fillers to suit wall finish thicknesses and to produce adequate bearing area to prevent bracket rotation and overstressing of substrate.

0.8 FINISHES

- A.** Comply with NAAMM's "Metal Finishes Manual for Architectural and Metal Products" for recommendations for applying and designating finishes.
- B.** Finish metal stairs after assembly.

- C.** Galvanizing: Hot-dip galvanize items as indicated to comply with applicable standard listed below:
1. ASTM A 123/A 123M, for galvanizing steel and iron products.
 2. ASTM A 153/A 153M, for galvanizing steel and iron hardware.
 3. Fill vent and drain holes that will be exposed in finished Work, unless indicated to remain as weep holes, by plugging with zinc solder and filing off smooth.
- D.** Preparation for Shop Priming: Prepare uncoated ferrous-metal surfaces to comply with minimum requirements indicated below for SSPC surface preparation specifications and environmental exposure conditions of installed products:
1. Exterior Stairs (SSPC Zone 1B): SSPC-SP 6/NACE No. 3, "Commercial Blast Cleaning".
 2. Interior Stairs (SSPC Zone 1A): SSPC-SP 3, "Power Tool Cleaning".
- E.** Apply shop primer to uncoated surfaces of metal stair components, except those with galvanized finishes and those to be embedded in concrete or masonry unless otherwise indicated. Comply with SSPC-PA 1, "Paint Application Specification No. 1: Shop, Field, and Maintenance Painting of Steel", for shop painting.

PART 3 - EXECUTION

0.1 INSTALLATION, GENERAL

- A.** Fastening to In-Place Construction: Provide anchorage devices and fasteners where necessary for securing metal stairs to in-place construction. Include threaded fasteners for concrete and masonry inserts, through-bolts, lag bolts, and other connectors.
- B.** Cutting, Fitting, and Placement: Perform cutting, drilling, and fitting required for installing metal stairs. Set units accurately in location, alignment, and elevation, measured from established lines and levels and free of rack.
- C.** Install metal stairs by welding stair framing to steel structure or to weld plates cast into concrete, unless otherwise indicated.
- D.** Provide temporary bracing or anchors in formwork for items that are to be built into concrete, masonry, or similar construction.
- E.** Fit exposed connections accurately together to form hairline joints. Weld connections that are not to be left as exposed joints but cannot be shop welded because of shipping size limitations. Do not weld, cut, or abrade surfaces of exterior units that have been hot-dip galvanized after fabrication and are for bolted or screwed field connections.

F. Field Welding: Comply with the following requirements:

1. Use materials and methods that minimize distortion and develop strength and corrosion resistance of base metals.
2. Obtain fusion without undercut or overlap.
3. Remove welding flux immediately.
4. At exposed connections, finish exposed welds and surfaces smooth and blended so no roughness shows after finishing and contour of welded surface matches that of adjacent surface.

G. Place and finish concrete fill for treads and platforms to comply with Section 033000 - CAST-IN-PLACE CONCRETE.

1. Install abrasive nosings with anchors fully embedded in concrete. Center nosings on tread width.

0.2 INSTALLING STEEL TUBE RAILINGS

A. Adjust railing systems before anchoring to ensure matching alignment at abutting joints. Space posts at spacing indicated or, if not indicated, as required by design loads. Plumb posts in each direction. Secure posts and rail ends to building construction as follows:

1. Anchor posts to steel by welding directly to steel supporting members.
2. Anchor handrail ends to concrete and masonry with steel round flanges welded to rail ends and anchored with postinstalled anchors and bolts.

B. Attach handrails to wall with wall brackets. Provide bracket with 1-1/2-inch clearance from inside face of handrail and finished wall surface. Locate brackets as indicated or, if not indicated, at spacing required to support structural loads. Secure wall brackets to building construction as follows:

1. Use type of bracket with flange tapped for concealed anchorage to threaded hanger bolt.
2. For concrete and solid masonry anchorage, use drilled-in expansion shields and hanger or lag bolts.
3. For hollow masonry anchorage, use toggle bolts.
4. For steel-framed gypsum board assemblies, fasten brackets directly to steel framing or concealed steel reinforcements using self-tapping screws of size and type required to support structural loads.

0.3 ADJUSTING AND CLEANING

A. Touchup Painting: Immediately after erection, clean field welds, bolted connections, and abraded areas of shop paint, and paint exposed areas with the same material as used for shop painting to comply with SSPC-PA 1 for touching up shop-painted surfaces.

1. Apply by brush or spray to provide a minimum 2.0-mil dry film thickness.
- B.** Galvanized Surfaces: Clean field welds, bolted connections, and abraded areas and repair galvanizing to comply with ASTM A 780.

PART 4 - MEASUREMENT AND PAYMENT

- A.** Metal stairs will be measured as per each complete in place, including all preparation, accessories and incidentals.

0.2 PAYMENT

- A.** Payment for metal stairs will be made at the Contract unit price for the quantities as specified above.

0.3 PAYMENT ITEMS

ITEM NO.	DESCRIPTION	UNIT
0551.001	METAL STAIRS	EA

END OF SECTION

NOTES TO THE DESIGNER

- A.** Any request to modify or waive the specification requirements listed below must be approved in writing by the MBTA's Director of Design:

1. None